

Date: Monday, 2/25/2008 11:14:27 AM
 User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASS'Y (A119)
Job Number : 37590A	
Estimate Number : 12445	
P.O. Number :	Part Number : D3515041
This Issue : 2/25/2008 S.O. No. :	Drawing Number : D3515 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 31751A	Material :
Written By :	Due Date : 3/17/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JA 08 02 26</u>	
Comment : EST rev A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22321	Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B35684

PD 08-03-05

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: B36860

PD 08-03-05

3.0	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B36920

PD 08-03-05

4.0	D2506	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B35585

FC 08 03 12

5.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481

PD 08-03-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:14:27 AM
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Drawing Name: BASKET LID ASS'Y (A119)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: B106199

PD 08-03-05

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

PD 08-03-05

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

PD 08-03-05

9.0

QC5/9

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/10

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: m 104218

FC 08 03 12

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

FC

2-Cut expanded metal for base ends as per dwg D3516

FC

3-Weld expanded metal to base as per dwg D3516

FC

08 03 12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:14:27 AM
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Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37590A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-13 ①

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-13 ①

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m/07005

FL 08/03/14 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-12 08/03/14 ①

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk: m/107385

black spray paint: m/107230

FL 08/03/14 ①

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 08-03-14 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 08-03-14

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 08/03/19 ①

Job Completion



U 08-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

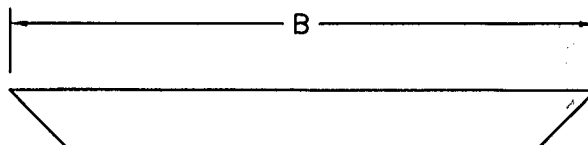
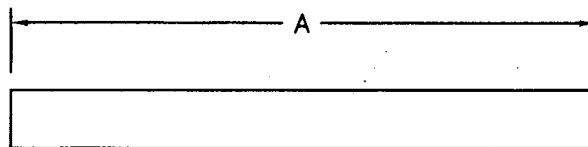
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED06.11.17 *[Signature]***PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH		DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



106813

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WORK ORDER
NO. 37590

D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

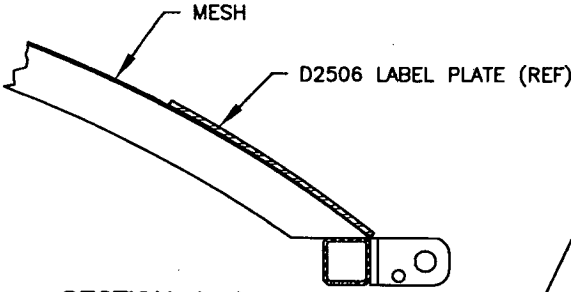
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06.11.17



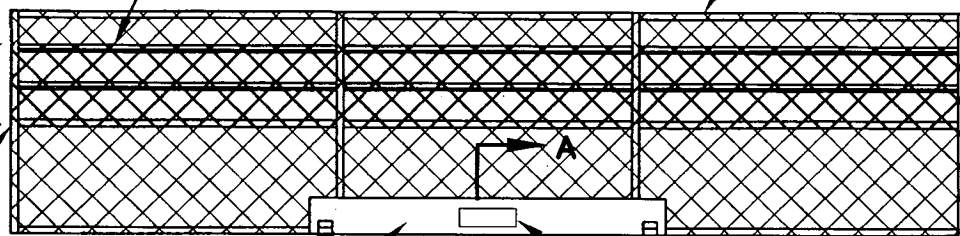
SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT

TACK WELD MESH TO
FRAME AT EVERY AVAILABLE
LOCATION IN AREA TO BE
ANTI SKIDDED

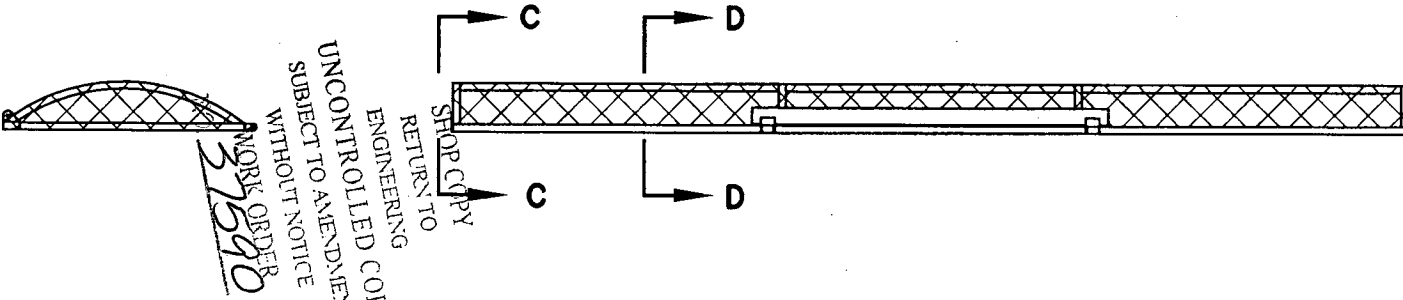
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D3515-041 BASKET LID ASSEMBLY

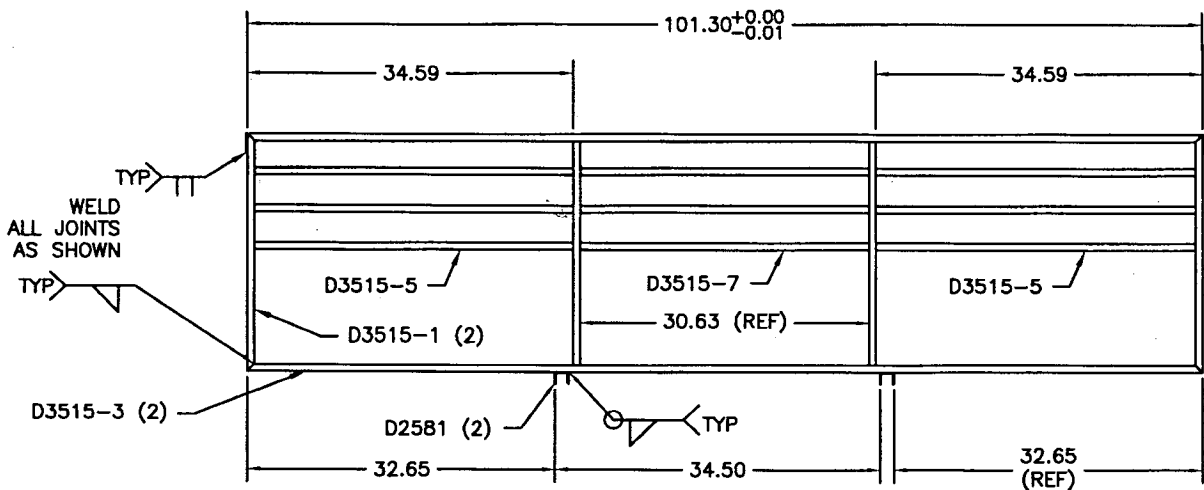
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 4
DATE		TITLE	SCALE
06.05.05		BASKET LID ASSEMBLY (A119)	1:20
		HAWKESBURY, ONTARIO, CANADA	

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WORK ORDER
375940

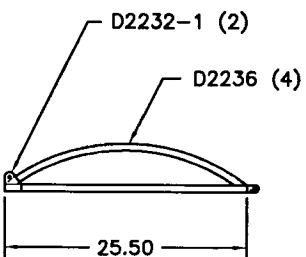
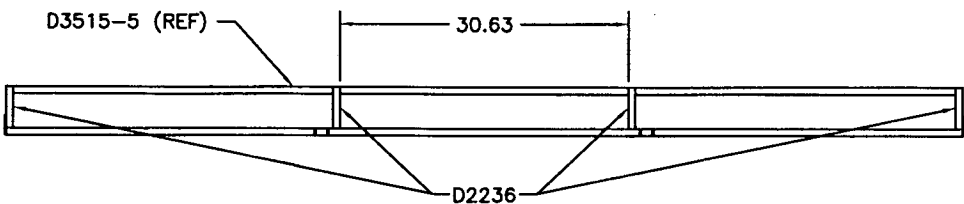
DART

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CHECKED	APPROVED	DRAWING NO. D3515	SHEET 3 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20	



DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

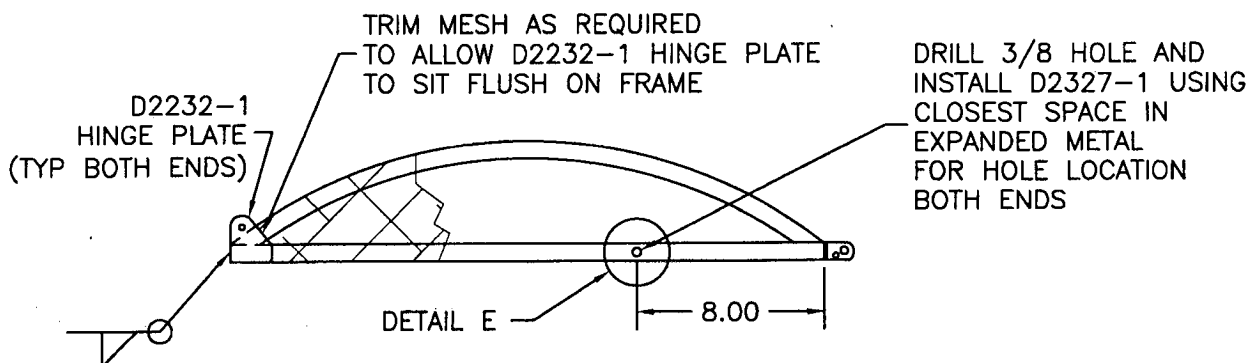


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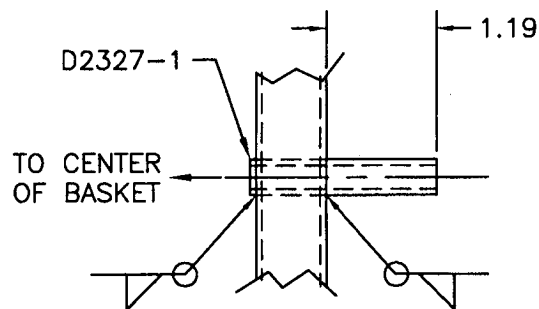


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

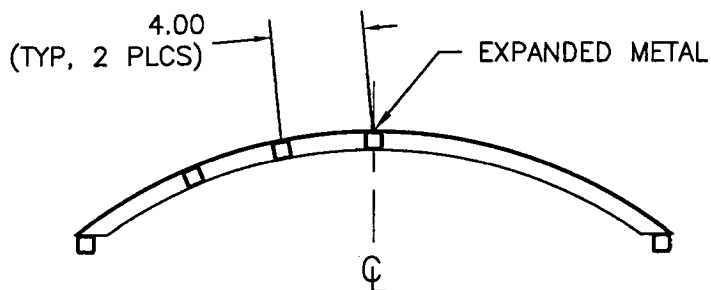


SECTION C-C SIMILAR BOTH END RIBS

RELEASED
06-11-17 *[Signature]*



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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